QC2- Inspect parts off machine FAI/FAIB

Memo

110

Quality Control

Work Orde October-07-13 8					* /	I	920*						Page 1
Revision ID:	D3903-1 Spacer				Accept		*N900	040	100)*	Setup Sta	I.V	S1*
	10/07/13	Start Qty Req'd Qty		*40* *40*			Cust Item II Customer:	D:				I	
	Process I	Plan: MC	5	Date: 13-10-0	7 Tooling: SPC (Y/N	l):		te: te:			Run Sta Sto		R1* R2*
Sequence ID/ Work Center ID	*	Operation Descriptio			Set Up Run H		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	R	evision Nbr											-
100 Hardinge Hardinge CNC Lathe	Small	1 1	FOLIO REV DWG REV:		0.00 0.00 WG D3903,	0AS 44 9-89	13/10/55	0.0		44	Ø		

0.00

0.00 CAS 13/(0/22

3

											DQA:	Date:	!
NCR: Y	⁄es	/ No				WORK ORDER NON-	COI	NFORN	/ANCE / UPI	DATE			
					··· 					<u> </u>	QA Closed	Date:	
Work Orde	>r·					DISPOSITION				AGAINST D	EPARTMENT	PROCESS	
Part N	- . No.					Rework Skid-tube Scrap Machining Use-as-is Thermoforming Large Fab			Machining noforming	Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	П	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUI	LT CATE	JORY				
Landi	mding Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube				o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/U nance led	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned	ect lissing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	l	Ripples in	ı Bend			Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Work Orde October-07-13 &		7920			Page 2						
Revision ID:	D3903-1			Accept	*N900	040	100)* s	etup Star Sto	I VI .	S1*
	Spacer		di A 🔾 di						510	* *N	S2*
	10/07/13	Start Qty: 40.00	*40*		Cust Item II	D:					
Required Date: Reference:	10/21/13	Req'd Qty: 40.00	*40*		Customer:						
Approvals:	Process Pla	nn:	Date:	Tooling:	Da	te:		R	tun Star		R1*
	QC:		Date:	SPC (Y/N):	Da	te:			Sto	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC8- Inspect parts - seco	nd check	0.00	_				/		DAC
120					13-10-23			44	4		DAS 13 13
QC Quality Control		Memo		0.00	÷				l		9-89
125				0.00							
125				0.00							
Skidtubes Skidtubes		Memo Clean spacer Batch:	s with Ultra Aluminum Cle	0.00 eaner				(H4)	Ø		
*130		Identify as per dwg & Sto	ck Location: 46	0.00	13-1	11-12		16	L.		

0.00

Memo

Packaging

Packaging

NCD-	Vac /	No	WORK ORDER NON-CO
NCK:	Yes /	INO	WORK ORDER NON-CO

WORK ORDER	NON-CONFORMANCE	/ UPDATE

DQA:

Date:

									QA Closed:	Dat	te:		
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS			
Part N					Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality		
NCR N	0		···········		Use-as-is Work Order Update	The	moforming Large Fab	Finishing Composite	Rec/Store/Packaging Other Supplier				
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &				
Cause	Date	Step	Qty	(or Non-conformance	Chief En	g Desc	cription	Date	Verification	n QC Inspector		
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process				:									
Supplier]						
Training													
Unapproved										l			
				• • • • • • • • • • • • • • • • • • • •	F	AULT CAT	EGORY						
Landin	ng Gear				General			_	-	•	_		
	Bending			<u> </u>	Bend	Grain		ļ	Ovalized		Pressure/Forced		
	Centre N	ot Conce	ntric to (o/s	BOM/Route	Hardv			Over/Under		Temperature/Cure		
	Cracks				Broken/Damaged	Inspe	tion Incomplete		Part Incorre	ct	Weld		
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs			. <u>L</u>	Contamination	Main	tenance		Part Moved				
	Heat Treat			Countersink	Misla	peled		Positioned V	Vrong				
					Cut Too Short	Misre		<u>[</u>	Power Loss/	Surge	Other		
Ripples in Bend Drill Hol				Drill Holes	Offset								
Torque Waves in Extrusion Drawing				Drawing	Out o	f Calibration							
Turning Sequence Finish					Finish	Out of Sequence							
Wave/Twist in Tube				1	Folio	Outsid	te Dimensions						

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Work Orde				*107920*							Page 3
Item ID: Revision ID: Item Name:	D3903-1 Spacer			Accept	*N900	040	100)*	etup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	10/07/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:					14.7/
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ite:	- 	F	Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):	Da	ite:				Stop	*NR2*
Sequence ID/ Work Center II 140 *140* QC Quality Control	D	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Qt		Reject Insp. Number Stamp 3 13-11-12

								DQA:	Date:	
NCR: Y	es / No			WORK ORDER NO	N-CONFO	RMANCE / UI	PDATE	QA Closed:	Date:	
Work Orde	r·			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Work Order: Part No. NCR No. Root Desc				Scrap	Rework Skid-tube Crosstube Machining Small Fab Use-as-is Thermoforming Finishing Composite			1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Description of work order update	e Initia	I A	ction	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling		-	ł							
Operator			ŀ							
Material										
Setup						+				
Other										
Process										
Supplier										
Training			1							

Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Contamination Maintenance Part Moved Countersink Mislabeled Positioned Wrong Heat Treat Other Inspection Strip in Tube Power Loss/Surge Cut Too Short Misread Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

FAULT CATEGORY

Grain

Hardware

Inspection Incomplete

Ovalized

Part Incorrect

Over/Under tolerance

Pressure/Forced

Weld

Temperature/Cure

General

Bend

BOM/Route

Broken/Damaged

Unapproved

Landing Gear

Bending

Cracks

Centre Not Concentric to O/S

Picklist Print

October-07-13 8:33:46 AM

Work Order ID: 107920

107920

Parent Item:

D3903-1

D3903-1

Parent Item Name: Spacer

Start Date: 10/07/13

Required Date: 10/21/13

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	206.0680	0.345	15			
*NACOCATA	TO 275	M OFO	r						**				

M6061T6T0 375W 058

6061-T6 RD Tube .375 x.058W

Location	Loc Qty	Loc Code	
MAT014	206.068		
116920	1.156	 	
119087	0.11		
123303	8	- A MALIA	
123449	16.336		
124069	8.266		
¥ M126335	172.2	16.25' 44 13/10/22	

Page 1

										DQA:	Date:	9. * 3
NCR: Y	es.	/ No				WORK ORDER NON-C	ONFORI	MANCE / UP		QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	_					Rework Scrap Use-as-is Work Order Update	i I	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data									1.11			
Equip/Tooling												
Operator												
Material												
Setup										į		
Other			ļ									
Process												•

Landing	Gear	General		_	_	_
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	_
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio	Г	Outside Dimensions		

FAULT CATEGORY

Supplier Training Unapproved

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DART AEROSPACE LTD	Work Order:	1070120
Description: Spacer	Part Number:	D3903-1
Inspection Dwg: D3903 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	°312.)		FK-04	Vern-
Ø0.259	+0.006/-0.001	، کر <i>ه</i> ۱	7		1	is .
4.080	+0.030/-0.000	4.097	7		\	12
0.030 x 45°	+/-0.010 x 0.5°	6030×45°	7		t,	1,
						<u> </u>
`						

	- CAS		<u> </u>	·	
Measured by:	44	Audited by:	& C &	Prototype Approval:	N/A
Date:	13/10/22	Date:	13-10-2]	Date:	N/A

Rev	Date	Change	Revis	ed by	Approved
Α	09.10.01	New Issue	KJ	*	

